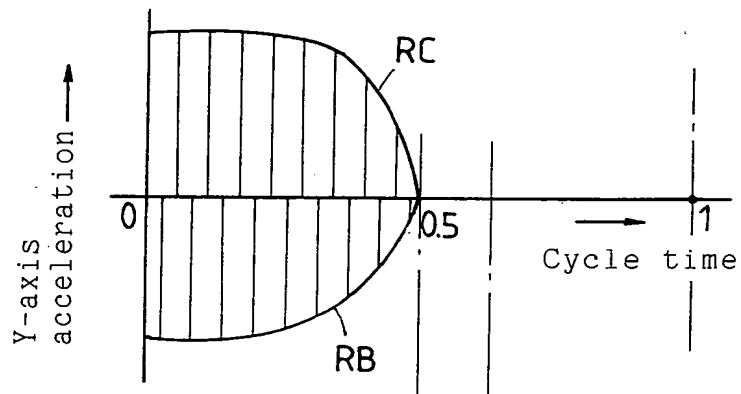


FIG. 1

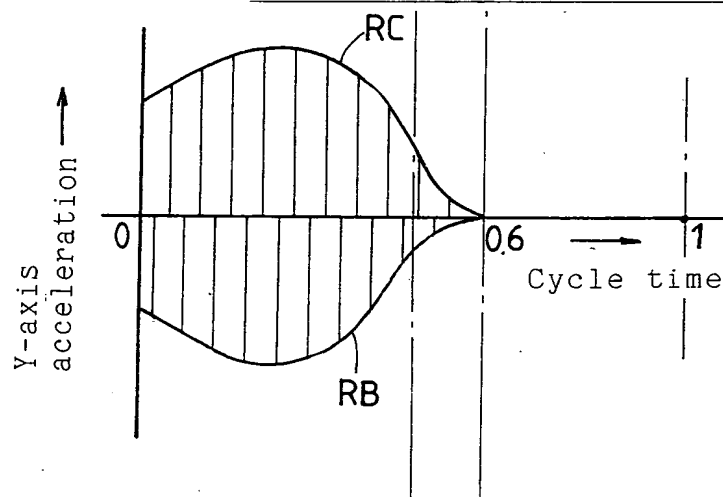
Rotating velocity of
work spindle rises on optimal curve

(A)



Rotating velocity of
work spindle rises linearly

(B)



Rotating velocity of
work spindle is kept constant

(C)

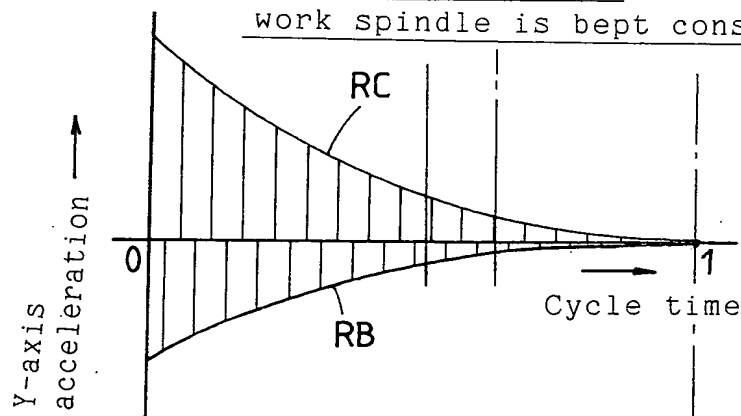


FIG. 2

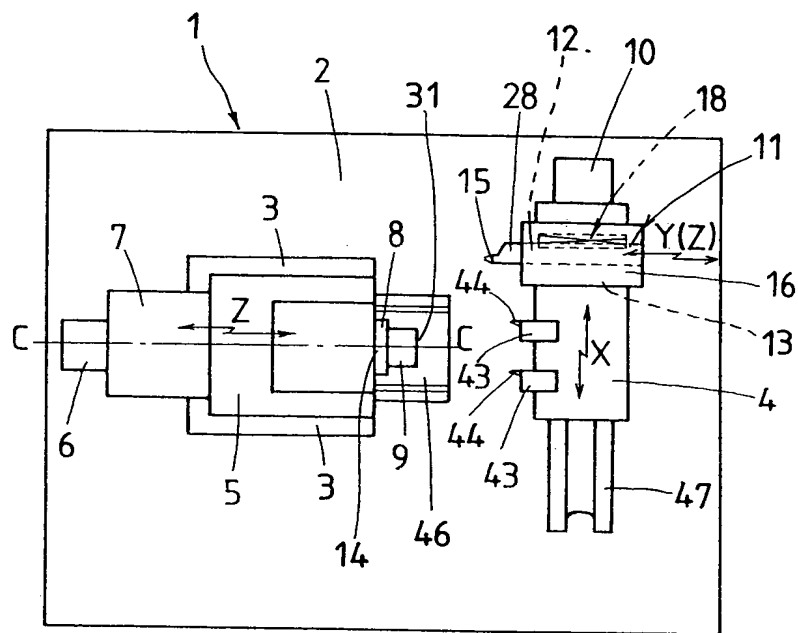


FIG. 3

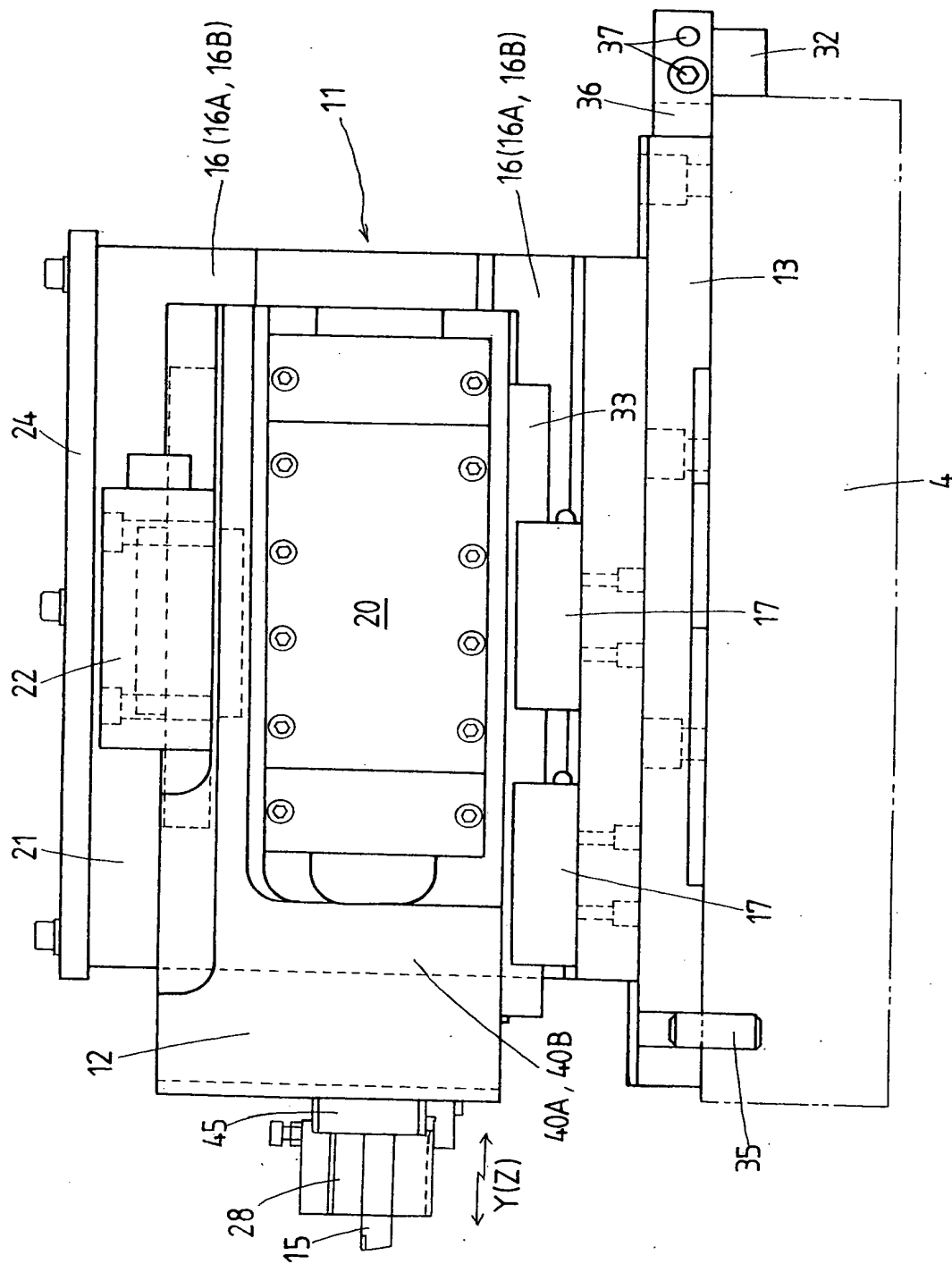


FIG. 4

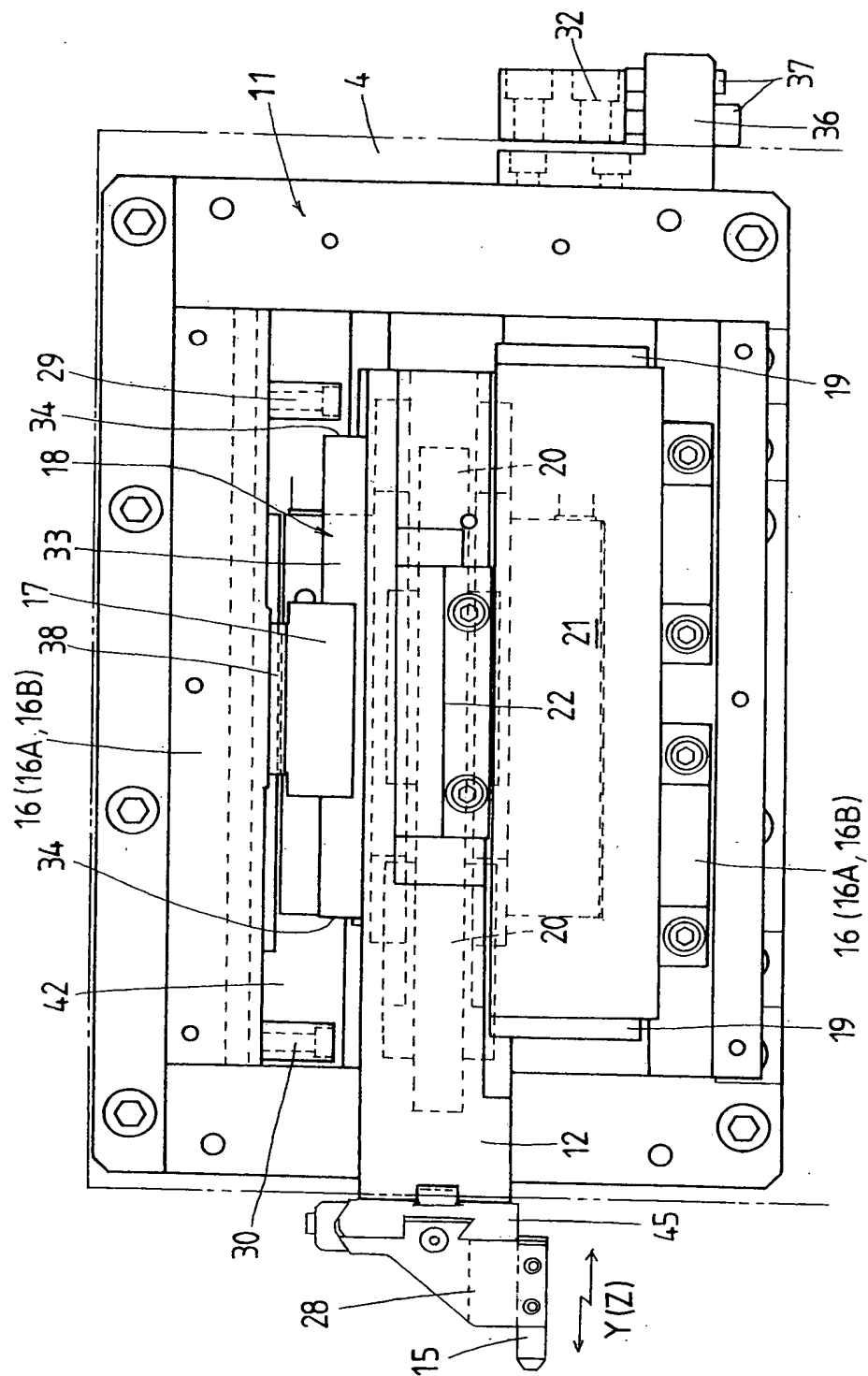


FIG. 5

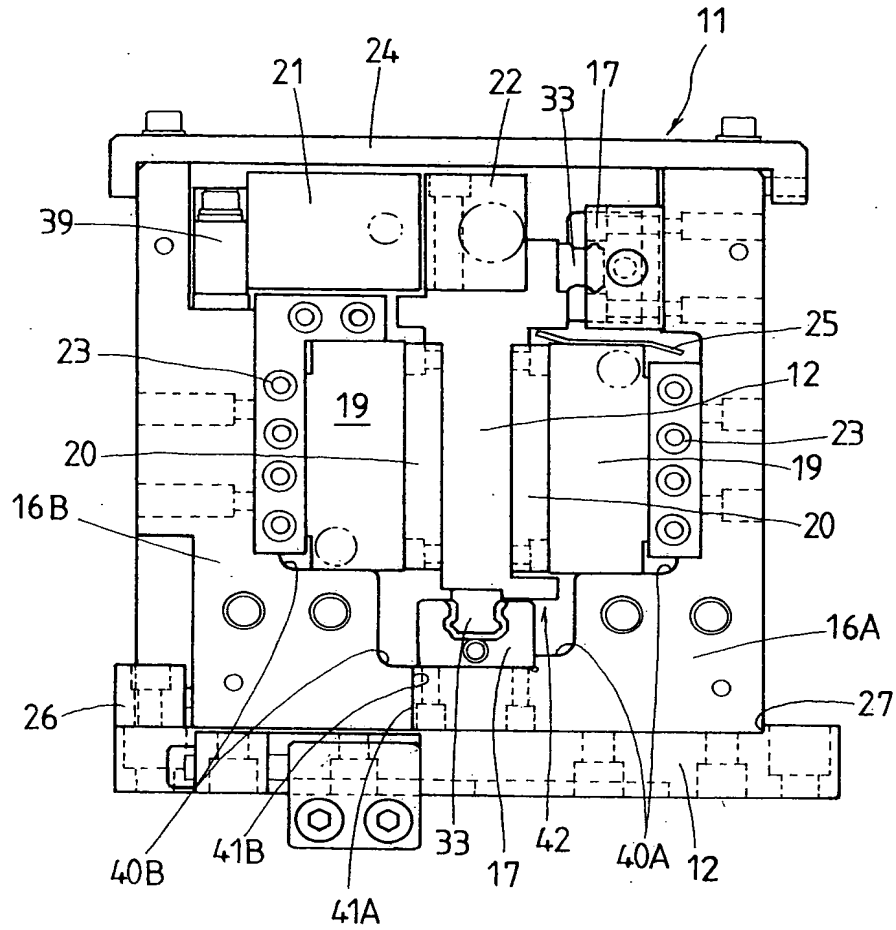


FIG. 6

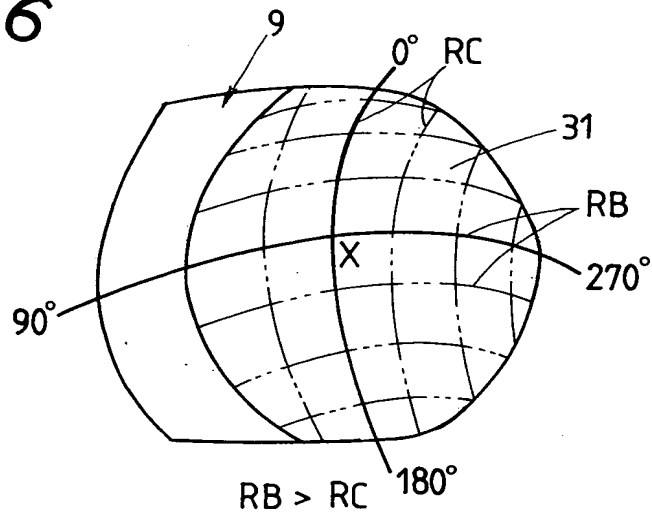


FIG. 7

